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DTAI-1038-045
Job Sheet 196934



Part No: DTAI-1038-045

Job Qty: 2 pcs

Part Name: Lower Cutter Installation, Short



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/25/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: SOLD

Description:

Note: DTAI-1038-045 REV.A IPP REV:A 17.09.12 NEW ISSUE DD VERF:JFS IPP REV.B 17.11.23 AS PER DWG
REVA5 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SprayPaint	2 pcs	7/5/19	7/5/19	0.00	0.54	Small Fab - 1		AUG 09 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Spray Paint - 1		
							Spray Paint - 2		
							Spray Paint - 3		
							Spray Paint - 4		
110	QC 5	2 pcs	7/5/19	7/5/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 1-1 - Pick Kit - B4B	2 pcs	7/5/19	7/5/19	0.00	0.00	Packaging 1 - 1 - B4B		
							Packaging 1 - 2 - B4B		

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					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
130	QC 4	2 pcs	7/5/19	0.00 0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
140	Packaging 3-1 - Stock - B4B	2 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
145 DC - 1 - B4B	2 pcs	7/5/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
150 QC 21 - SA	2 pcs	7/5/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - *****IMPORTANT*****PLEASE READY MSDS FOR PR1764 B2 PART A***USE PROPER PPE WHEN USING
 Descriptions: THIS PRODUCT*** CHEMICAL-RESISTANT BUTYL RUBBER GLOVES, CHEMICAL SPLASH GOGGLES AND FACE
 SHIELD, USE A PROPERLY FITTED, AIR-PURIFYING OR AIR FED RESPIRATOR, TO BE USE IN THE SPRAY PAINT
 BOOT***** ASSEMBLE AS PER DWG AND APPLY RTV TO ALL FAYING SURFACES (SEE NOTE 8-9) 8) APPLY
 LOCTITE 598 OR SIMILAR RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY. RTV 598

BATCH: 5173363 9) WET INSTALL FASTENERS USING PR-1764 CLASS B SEALANT OR EQUIVALENT
 MIL-S-8802 SEALANT. PR-174 BATCH: 5201953

110 - QC5- Inspect part completeness to step on W/O

120 - Pick Kit

130 - QC4- 100% Inspect kits for completeness

140 - Identify and pack for shipping as per PPP DTAI-1038-045 Location: _____ PPP Rev: _____

145 - Document Control - Photocopy bluefile and create labels as per PPP DTAI-1038-045 Chg 001

150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5501-043	Body, Lower Cutter Assembly, Short	2 pcs (1 ea)	100-SprayPaint	<u>5204177</u>
D5506-1	Base, Lower Cutter	2 pcs (1 ea)	100-SprayPaint	<u>5198421</u>
MS21042L08	Nut	6 Ea (3 ea)	100-SprayPaint	<u>5193124</u>
MS27039-08-19	Screw	6 Ea (3 ea)	100-SprayPaint	<u>5194128</u>
NAS1149FN832P	Washer (AN960-8)	12 Ea (6 ea)	100-SprayPaint	<u>5167594</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-SprayPaint	D5501-043	2	0	0
	D5506-1	2	4	1

Allocated Container Detail

Qty	Container No	Location	Init
1	S200791	cck009	_____
MS21042L08		6 439	3

Allocated Container Detail

Qty	Container No	Location	Init
3	S200792	over007	_____
MS27039-08-19		6 269	3

Allocated Container Detail

Qty	Container No	Location	Init
3	S200793	ga015	_____
NAS1149FN832P		12 1,414	6

Allocated Container Detail

Qty	Container No	Location	Init
6	S200794	st263	_____

Part Specifications

Specifications could not be found.

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Container No: S204187



Part: DTAI-1038-045

Job No: 196934

Serial No/Batch: S204187

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 08/09/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>196934</u> Part No. <u>DTAI-1038-CH5</u> <u>RBU.A</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date: <u>AUG 23/19</u>	Sequence #: _____	QTY Affected: <u>2</u>	MRB (QS1042) <u>MLe</u> <u>AUG 23/19</u>	
Description Work Order Deviation Ref. Eng. Note 10, 3A & 1C-SH5, D5501 Rev. $\phi 0.170$. Reqs. ~ ~ ~ Ream to final size after finishing touch up bare metal with electrically conductive chemical film material (AloDine 600) per mil-DTL-5541 Actual ~ No evidence & record for the operations being done in compliance <u>REF: D6609-3, 196942</u>		Disposition <u>QTY (1) $\phi 0.170$ HOLE (FLAG 10)</u> <u>HAS BEEN REAMED TO $\phi 0.173$ AFTER</u> <u>FINAL ASSY. REASSEMBLED USING</u> <u>ORIGINAL HARDWARE PER DRAWING.</u> <u>PROBEAL PR-1764 B/N _____</u> <u>ALL BARE ALUMINUM MUST BE TOUCHED</u> <u>UP WITH ALOPDINE 600.</u> <u>NO DEVIATIONS, REWORK TO DWG</u>		Completed By Lead hand / Supervisor QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☒ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☒ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____				

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>196934</u> Part No. <u>DTAR-1038-045</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
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Date: _____	Sequence #: _____	QTY Affected: <u>4 of 4</u>	MRB (QSI042) <u>MPL</u>
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Description Work Order Deviation	Disposition	Completed By
Ref. Eng. Note 9, SA & TB-SH1, DWG 5506 Rev A Req: ... Ream to final size after finishing Touch up bare metal with ECC film material (Alodine) per MTL-DTL-5541 Actual: No evidence & record to demonstrate its being done in operations for compliance. REF: D6606-1, 196941	QTY (1) ϕ 0.170 (SLAG 9) HAS BEEN REAMED TO ϕ 0.173 AFTER FINAL ASSY. ALL BARE ALUMINUM HAS BEEN REATED UP WITH WITH ALODINE 600. REASSEMBLED USING ORIGINAL HARDWARE. PROSIAL PIS-1764 B/N _____ NO DEBURATION, REWORK TO DWS	<u>AUG 23/19</u> Lead hand / Supervisor QC / QA Coordinator

Root Cause	FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☒ Human Factors ☐	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☒ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
Other/Details: _____				